

Work Order ID 52965

October 19, 2009 2:38:23 PM

Page 1

Item ID: D3290-041
 Revision ID: C1 *9/11/07*
 Item Name: Replacement Window Assembly

Start Date: 10/19/09 Start Qty: 10.00
 Required Date: 10/23/09 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *[Signature]* Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Cust Item ID:
 Customer:

Setup Start
 Stop
 Run Start
 Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	DEO Rev C1								

100
 FLOW WATER JET
 Waterjet
 FLOW CNC Waterjet
 Memo
 1-Cut as per Dwg D3290 (use prog. for D3290-1)
 Dwg Rev: *C1*
 Prog Rev: *9/11/07*
 2-Deburr if necessary

110
 QC2- Inspect parts off machine FAI/FAIB
 QC
 Quality Control
 Memo

120
 QC8- Inspect parts - second check
 QC
 Quality Control
 Memo

2) 807/10/22

HB 9-10-21
HB 9-10-21
(710) /

Work Order ID 52965

October 19, 2009 2:38:23 PM



Page 2

Item ID: D3290-041
Revision ID: C1
Item Name: Replacement Window Assembly

Accept



Setup Start



Stop



Start Date: 10/19/09 Start Qty: 10.00
Required Date: 10/23/09 Req'd Qty: 10.00



Cust Item ID:
Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number
130	Chemical Conversion Coat per QSI005 4.1	0.00						
	HandFinish	0.00				(X10)	0	
	Hand Finishing							
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00						
	Powdercoat	0.00				(X10)	0	
	Powder Coating							
150	QC3- Inspect Part Finish	0.00						
	QC	0.00						
	Quality Control							

Memo

Memo

START TIME: 12:45pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:15pm

Memo

Work Order ID 52965

October 19, 2009 2:38:24 PM

Page 3

Item ID: D3290-041

Accept

Revision ID: C1

Item Name: Replacement Window Assembly

Start Date: 10/19/09 Start Qty: 10.00

Required Date: 10/23/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

169



Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3290
Clean D3290-041 and place in plastic wrap

0.00

SAD 09-10-21

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

2) 8014102

(410) f

180



Packaging

Packaging

Identify as per dwg & Stock Location 219

Memo

0.00

0.00

9/11/12 10051

Work Order ID 52965

October 19, 2009 2:38:24 PM

Page 4

Item ID: D3290-041

Accept

Setup Start

Revision ID: C1

Stop

Item Name: Replacement Window Assembly

Start Date: 10/19/09 Start Qty: 10.00

Cust Item ID:

Required Date: 10/23/09 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Reject
Qty

Reject
Number

Insp.
Stamp

000

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/03

MF

09-10-02

Picklist Print

October 19, 2009 2:38:22 PM

Page 1

Work Order ID: 52965

Parent Item: D3290-041RevC

Parent Item Name: Replacement Window Assembly


Start Date: 10/19/09

Required Date: 10/23/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	33.2841	39.4737			
												
6061-T6 .063 Sheet												

189-10-21

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

33.28412105

110551

33.2841211

112939

160

f

436.0334

65.0000

112939

D2126RevC

Manufactured

No

Seal

SAD 09-10-31

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

436.0334

42154

51.7

48285

384.3334

65.00

(D2126-0780) cut qty (1) at 78.00" as per dwg

per kit

D3290-3RevC

Manufactured

No

160

Each

4.0000

10.0000

SAD 09-10-30

Window

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

4

47693

4

52356

x9

9

DART AEROSPACE LTD		Work Order: 52965
Description: Window Frame		Part Number: D3290-1
Inspection Dwg: D3290	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

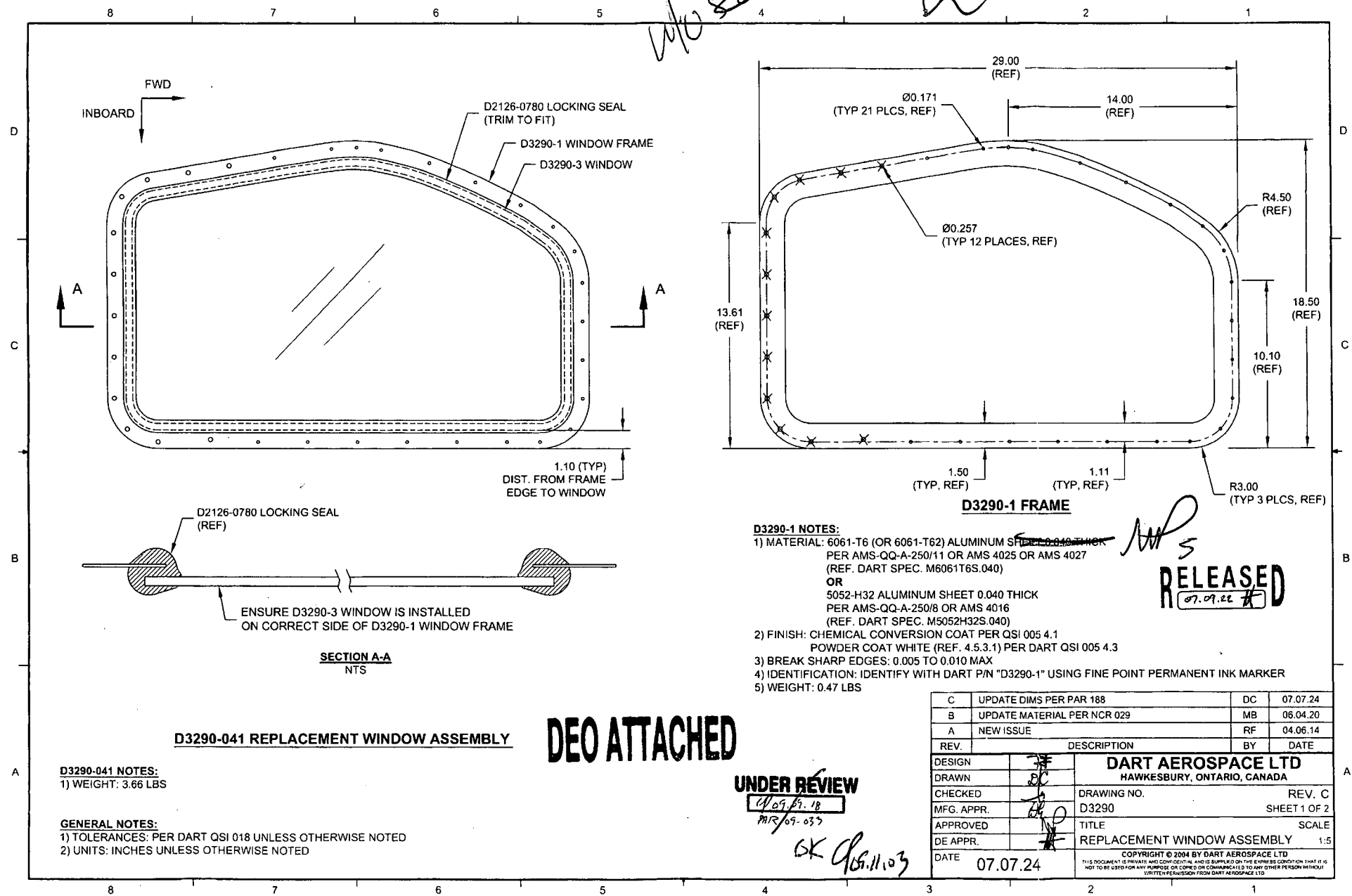
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	r			
14.00	+/-0.030	14.00	x			
Ø0.171	+0.005/-0.001	.173	x			
1.50	+/-0.030	1.507	#			
1.11	+/-0.030	1.110	F			
10.10	+/-0.030	10.10	x			
18.50	+/-0.030	18.50	x			
0.040	+/-0.010	.063	+			
R3.00	+/-0.030	3.00	x			
R4.50	+/-0.030	4.50	x			
Ø0.257	+0.006/-0.001	.261	*			
13.61	+/-0.030	13.61	*			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-10-21	Date: 09/10/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	B

W/ 52965



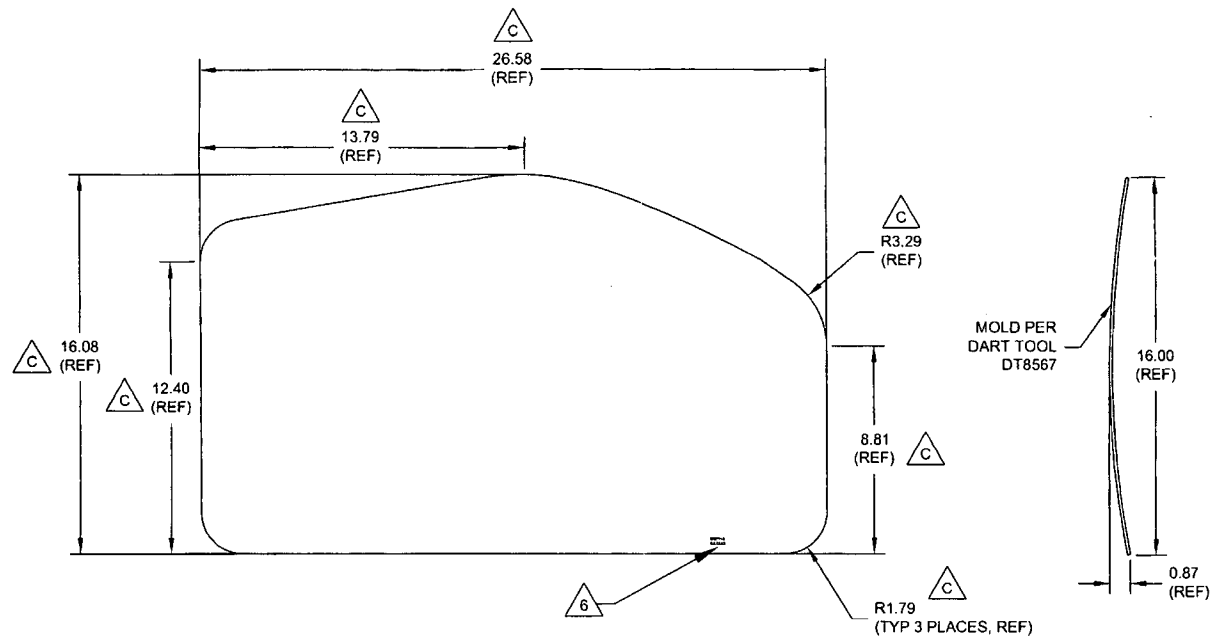
- D3290-1 NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.040) OR 5052-H32 ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
 - 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
 - 5) WEIGHT: 0.47 LBS

RELEASED
07.07.22

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3290	REV. C SHEET 1 OF 2
TITLE REPLACEMENT WINDOW ASSEMBLY	SCALE 1:5
COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/ 52965



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567







UNDER REVIEW

07.07.18

07.11.03

RELEASED

07.07.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY 1:	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>h</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>			
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21	DATE 09/09/21			

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

WLO 52965
52558

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
2009 -10- 09

WMP

COPYRIGHT © 2009 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.